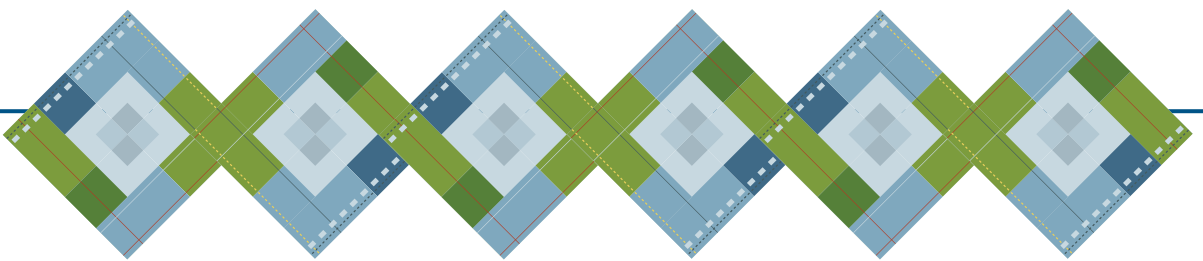


TECHNOLOGY AND KNOWLEDGE TRANSFER

KEYS TO SUCCESSFUL
IMPLEMENTATION AND
MANAGEMENT



Mark Gibson and Siegfried Schmitt
Editors

CONTENTS

I	INTRODUCTION AND OBJECTIVES	I
	<i>Mark Gibson and Siegfried Schmitt</i>	
	Purpose of the Book	I
	Technology Transfer and the Drug Discovery and Development Process	5
	Why is Technology Transfer Important?	11
	Scope of the Book	13
	References	18
	About the Authors	20
2	TECHNOLOGY TRANSFER AND KNOWLEDGE MANAGEMENT OVER THE DRUG LIFECYCLE	23
	<i>Siegfried Schmitt</i>	
	Introduction	23
	From Data to Knowledge	25
	Transferring or Sharing Data and Knowledge	26
	Knowledge Sharing Standard Operating Procedure (SOP)	31
	Final Conclusions	32
	References	33
	About the Author	33

3	TECHNOLOGY TRANSFER, THE REGULATORY AND BUSINESS PERSPECTIVE	35
	<i>Alan Harris and Siegfried Schmitt</i>	
	Introduction	35
	Regulatory Requirements for Technology Transfer	36
	Electronic Records/Electronic Signatures (ER/ES)	42
	Safety, Health and Environmental (SHE) Regulations	42
	General Safety and Health Considerations	42
	Waste Disposal	44
	Potential Impact of the Regulations Concerning Import/Export of Chemicals	45
	Economic Factors	46
	New Technology	47
	Social Aspects and the Impact on Technology Transfer	50
	Language	50
	Culture	52
	Team Building	52
	Conclusions	54
	References	55
	About the Authors	57
4	TECHNOLOGY TRANSFER ORGANISATION STRATEGY AND PLANNING	59
	<i>Steve Burns and Mark Gibson</i>	
	Introduction	59
	Stages of the Technology Transfer Process	62
	Stage 1: pre-technology transfer preparation	63
	Stage 2: scale-up and establish process at commercial scale	71
	Stage 3: plan and perform process validation	73
	Management of Change	76
	Organisation	77
	Teams Supporting the Technology Transfer Process	80
	Global Technology Transfer Management Team (GTTMT)	80
	Sending site (R&D) drug substance project team	82
	Sending site (R&D) drug product project team	82
	Receiving site(s) project teams	85
	Documentation Required to Support Technology Transfer	87
	Planning	89
	Timings	90
	References	93
	About the Authors	94

5	CHEMICAL DRUG SUBSTANCE DEVELOPMENT AND TECHNOLOGY TRANSFER	97
	<i>Alan Harris</i>	
	Introduction	97
	The Drug Substance Development Process	98
	Introduction to drug substance process research and development	98
	The role of process R&D	100
	Good process design	103
	The challenge of discontinuous development	108
	Barriers to process changes	110
	Introduction to Technology Transfer for Drug Substance	111
	Aims of Technology Transfer	113
	The Impact of Technology Transfer Issues on Process	
	Development Strategies	114
	Early development decisions	114
	Route selection, regulatory and sourcing strategies	116
	Process freeze	117
	Potential Impact of REACH Regulations	118
	Applying Risk Analysis and Risk Management to Technology Transfer Decisions	119
	Managing the Technology Transfer Programme	120
	Principles for technology transfer	121
	The technology transfer team	122
	Documentation to be Transferred or Generated During Technology Transfer and Establishment of the Process	123
	Success Criteria for Technology Transfer	124
	Process Validation	125
	Case Study 1: Remacemide Hydrochloride	129
	Early process evaluation	129
	Process R&D work	131
	Early technology transfer of the process for DPAP	131
	Second source for DPAP	134
	Technology transfer of the final stages of the process	135
	Salt selection, polymorphism and particle size	136
	Lessons from case study 1	136
	Case Study 2: Sibenadet Hydrochloride	138
	Synthesis and technology transfer of the benzothiazolone amine intermediate	138
	Synthesis and technology transfer of the intermediate benzoate ester	141
	Technology transfer of the final steps	141
	Control of physical form	143

Crystallisation/drying issues	144
Overall lessons from case study 2	145
Case Study 3: Gefitinib (Iressa®)	147
Overall lessons from case study 3	151
Future Directions for Process Development and the Impact on Technology Transfer	152
Microwave and ultrasonic reactors	152
Micro-reactors technology and continuous processes	153
Chromatographic purification techniques	153
Overall Conclusions	154
References	157
About the Author	160
6 CHEMICAL DRUG PRODUCT DEVELOPMENT AND TECHNOLOGY TRANSFER	161
<i>Mark Gibson</i>	
Introduction	161
Product Design	168
Product Optimisation	172
Process Design and Optimisation	177
Process Capability and Robustness	182
Use of PAT to Aid Process Optimisation and Understanding	183
Scale-up and Technology Transfer	187
Process Validation	190
Clinical trials process validation	191
Cleaning validation	192
Process validation of the commercial process	
— acceptance by production	194
Post-validation and Post-regulatory Approval Changes	200
Documenting the Drug Development Process	203
Chemical (Small Molecules) Drug Product Technology	
Transfer Case Studies	206
Case study 1: immediate release film coated tablet	206
Case study 2	211
Case study 3: metered dose inhaler	213
References	215
About the Author	218

7	DRUG SUBSTANCE MANUFACTURING PROCESS DEVELOPMENT AND TECHNOLOGY TRANSFERS — BIOPHARMACEUTICALS	219
	<i>Lamine Bouakaz</i>	
	Introduction	219
	Biopharmaceutical Drug Substances	221
	Characteristics of biopharmaceutical drug substances	221
	Biopharmaceutical vs. chemical manufacture	223
	Development Phases for Biopharmaceuticals	226
	Pre-clinical program for biopharmaceuticals	226
	Clinical trials program for biopharmaceuticals	229
	Registration of biopharmaceuticals	230
	Commercialization and product lifecycle: Phase IV	231
	Development of Biopharmaceutical Drug Substance	
	Manufacturing Processes	232
	Overview of biopharmaceuticals drug substance manufacturing processes	233
	The Quality Target Product Profile	235
	Process development for pre-clinical drug substance manufacture	236
	Process development for Phase I/II biopharmaceutical drug substance manufacture	240
	Phase III biopharmaceutical drug substance manufacturing process development	249
	Process and product characterization studies	260
	Process validation	263
	Registration	266
	Knowledge management	268
	Biopharmaceutical Drug Substance Manufacturing Process	
	Technology Transfer from Development to Commercial Scale	268
	Preclinical to Phase I/II manufacturing process technology transfer	269
	Phase I/II to Phase III manufacturing process technology transfer	274
	Biopharmaceutical Drug Substance Manufacturing	
	Process Technology Transfer between Commercial Manufacturing Sites	278
	References	284
	Abbreviations	286
	About the Author	288

8	ANALYTICAL METHODOLOGY AND SPECIFICATIONS	289
	<i>Mark Hindle</i>	
	Introduction	289
	Method transfer scope	291
	Analytical technology transfer: what to do before formal transfer starts	292
	QC involvement during method validation	295
	QC involvement post validation	296
	Analytical technology transfer: when does it start and when does it end?	297
	Principles of analytical methodology transfer	299
	Change control	302
	Competition and timing	303
	The Technology Transfer Process for Analytical Methodology and Specifications	303
	Stages of analytical method transfer	304
	Stage 1: Analytical Strategy	306
	Analytical method transfer team	306
	Analytical transfer strategy document	309
	Stage 2: Knowledge and Information Transfer	313
	Information package	314
	Knowledge transfer	315
	Stage 3: Method Transfer Protocol	320
	Testing design	322
	Use of statistics	328
	Approval of method transfer protocol	330
	Stage 4: Analytical Testing	331
	Stage 5: Summary Report	333
	Transfer approval	333
	Post transfer monitoring	334
	Post approval changes	334
	Method transfer — potential problems and how to avoid them	335
	Summary	345
	References	346
	About the Author	348
	APPENDIX: SPECIAL CONSIDERATIONS FOR TRANSFER OF BIOASSAY METHODS	349
	<i>Sharon Longhurst and Ralf Hess</i>	
	Introduction	349
	Cell Based Assays	351

Issues for Consideration with Respect to Analytical Transfer Strategy	352
Knowledge and Information Transfer	355
Method Transfer Protocol	356
Ligand Binding Assays	358
Issues for Consideration with Respect to Analytical Transfer <i>In Vivo</i> Assays	359
Issues for Consideration with Respect to Analytical Transfer Strategy	360
Knowledge and Information Transfer	360
Method Transfer Protocol	361
References	361
About the Authors	362
9 TECHNOLOGY TRANSFER, OUTSOURCED ACTIVITIES MANAGEMENT	365
<i>Siegfried Schmitt</i>	
Introduction	365
The purpose of technical/quality agreements	365
What are technical/quality agreements?	366
Quality Agreements	367
Applicable regulations	
Minimum Requirements for Contents of a Technical/Quality Agreement	371
Key Performance Indicators for Compliance Through Quality Agreements (PQA, <i>premier-research.com</i>)	375
Challenges to Companies in Developing Quality Agreements	377
Summary	377
Examples	378
References	378
About the Author	379
10 AUDITS AND INSPECTIONS	381
<i>Mark Gibson</i>	
Introduction	381
The PAI Process	385
Common PAI Deficiencies	390
PAI — What will be Inspected?	392
PAI — How to Prepare?	395

Documented PAI policy	395
Formation of PAI preparation team(s)	396
Documentation, data review and retrieval	399
Product development reports	402
Good level of cGMP and compliance	406
Training and awareness	406
PAI and Launch	408
Technology Transfer: Final Conclusions	409
References	411
About the Author	412
II TRAINING, AN ESSENTIAL ELEMENT OF TECHNOLOGY TRANSFER	415
<i>Siegfried Schmitt</i>	
Introduction	415
The Quality by Design Challenge	416
Learning from Technology Transfer	417
Developing a Training Strategy	418
Scope of training	418
Prioritisation and context of training needs	419
Detailed contents of training programmes	420
Methods and tools for delivering training	421
Management of training programmes	422
Trainers	423
Templates and style guidelines	423
Training documentation	424
Language used for training programmes	425
Measuring the Success of Training	425
Auditing of Training	425
Conclusions	426
References	426
About the Author	427
Glossary	429
Index	459